

28x51

Work Order ID 62360

Tuesday, September 28, 2010 11:20:35 AM



Page 1

Item ID: D3875-1

Accept



Setup Start



Revision ID:

Item Name: Floor Protector

Stop



Start Date: 9/28/2010 Start Qty: 3.00



Cust Item ID:

Required Date: 10/5/2010 Req'd Qty: 3.00



Customer:

Reference:

Approvals:

Process Plan:

Date: 10/9/28

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D3875	Rev A

100



HandThermo

Hand Finishing Thermoforming

Memo

1-Cut Sheet to required Blank size

0.00

10/10/06

105



Dry Material

0.00

HandThermo

Hand Finishing Thermoforming

Memo

Dry Sheet as per PSH022 POLYCARBONATE

Temp:

249

Time IN: 7:30 10/10/05

Time OUT: 7:00 10/10/06

10/10/06

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

110



Thermoform

Thermoforming Machine

Memo

0.00

1-Machine Set-Up
 2-Pre-heat Tool to required temp.
 3-Thermoform as per Dwg and Folio #FTA0xxusing tool DT9435
 Dwg Rev: A
 Folio Rev: B



BB 10/10/06.

(X3) BB 10/10/06.

120



QC2- Inspect parts off machine FAI/FAIB

0.00

QC

Quality Control

Memo

0.00

Visually inspect part for proper formation and texture

BB 10/10/06.

130



QC8- Inspect parts - second check

0.00

QC

Quality Control

Memo

0.00

SL 10/10/06

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Setup Start



Revision ID:

Item Name: Floor Protector

Stop



Start Date: 9/28/2010 Start Qty: 3.00



Cust Item ID:

Required Date: 10/5/2010 Req'd Qty: 3.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

140



HandThermo

Hand Finishing Thermoforming

Memo

1-Trim to finished dimensions as per Dwg

0.00

X3 Sh. 10/10/07

150



QC

Quality Control

QC2- Inspect parts off machine FAI/FAIB

0.00

Memo

Complete FAI document

0.00

X3 Sh. 10/10/07

160



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

8/10/10/12

X3

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Tuesday, September 28, 2010 11:20:35 AM

Item ID:	D3875-1	Accept		Setup	Start				
Revision ID:									
Item Name:	Floor Protector								
Start Date:	9/28/2010	Start Qty:	3.00		Cust Item ID:				
Required Date:	10/5/2010	Req'd Qty:	3.00		Customer:				
Reference:							Run	Start	
Approvals:	Process Plan:	Date:	Tooling:	Date:		Stop			
	QC:	Date:	SPC (Y/N):	Date:					

Sequence ID/ Work Center ID	Operation Description	Memo	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
170 	Identify as per dwg & Stock Location:		0.00							<i>Per 10/13 3)</i>
Packaging				<i>PPP</i>	<i>62359</i>					
Packaging										
180 	QC21- Final Inspection - Work Order Release	Memo	0.00							<i>10/10/13 JF</i>
QC Quality Control										
										<i>MF 10-10-13</i>

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Picklist Print

Page 1

Tuesday, September 28, 2010 11:20:39 AM

Work Order ID: 62360



Parent Item: D3875-1



Parent Item Name: Floor Protector

Start Date: 9/28/2010

Required Date: 10/5/2010

Start Qty: 3.00

Required Qty: 3.00

Comments: IPP Rev. A 09.02.06 New Issue DL
Add Step 105 Dry Material 10/04/21 DL

IPP Rev.B

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MLEXS.118-90318-08		Purchased	No			100	sf	2,497.890	9.84	29.52			

Lexan Sheet

Location
therm
113127

Loc Qty
2497.89
2497.89

Loc Code

3

10/10/06.

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DART AEROSPACE LTD	Work Order:	62300
Description: Floor Protector	Part Number:	D3875-1
Inspection Dwg: D3875 Rev: A		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

First Article Prototype

THERMOFORMING SECTION

Description	Accept	Reject	Method of Inspection	Comments
Inside Radii less than "	✓			
Shape Definition	✓			
Texture Retention	✓			
Material imperfections such as bumps, cracks, voids, scratching	✓			

Measured by: *W.H.* Date: *10/10/07*

TRIMMING SECTION

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.050	Min	0.062"	✓			
0.080	Min	0.083"	✓			
45.2	+/-0.100	45.25"	✓			
21.8	+/-0.100	21.8"	✓			
1.4	+/-0.100	1.44"	✓			

Measured by: *W.H.* Date: *10/10/07*

Audited by: *[Signature]* Date: *10/10/07*

Prototype Approval: N/A Date: N/A

Rev	Date	Change	Revised by	Approved
A	09.09.15	New Issue	KJ	<i>[Signature]</i>

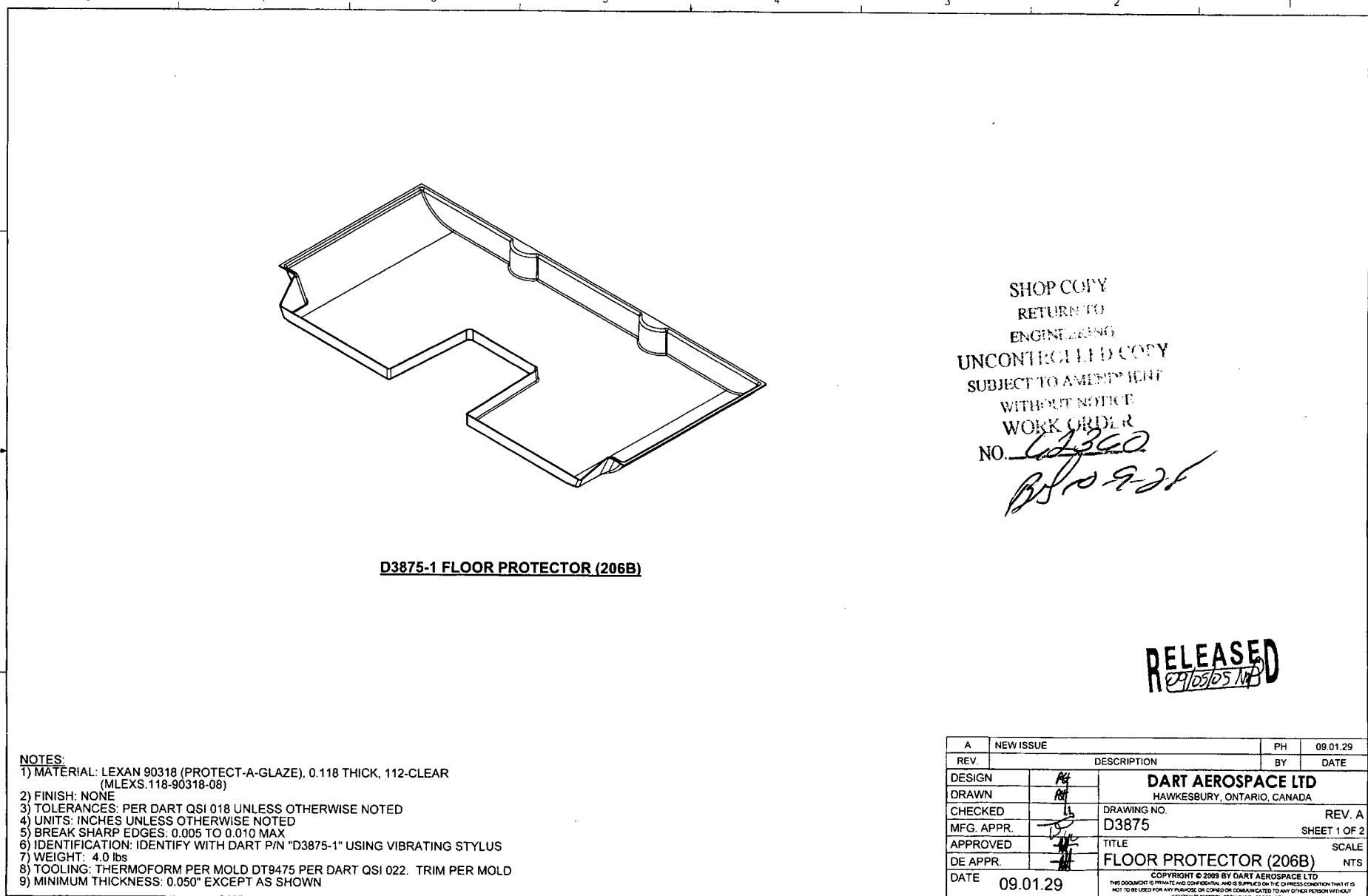
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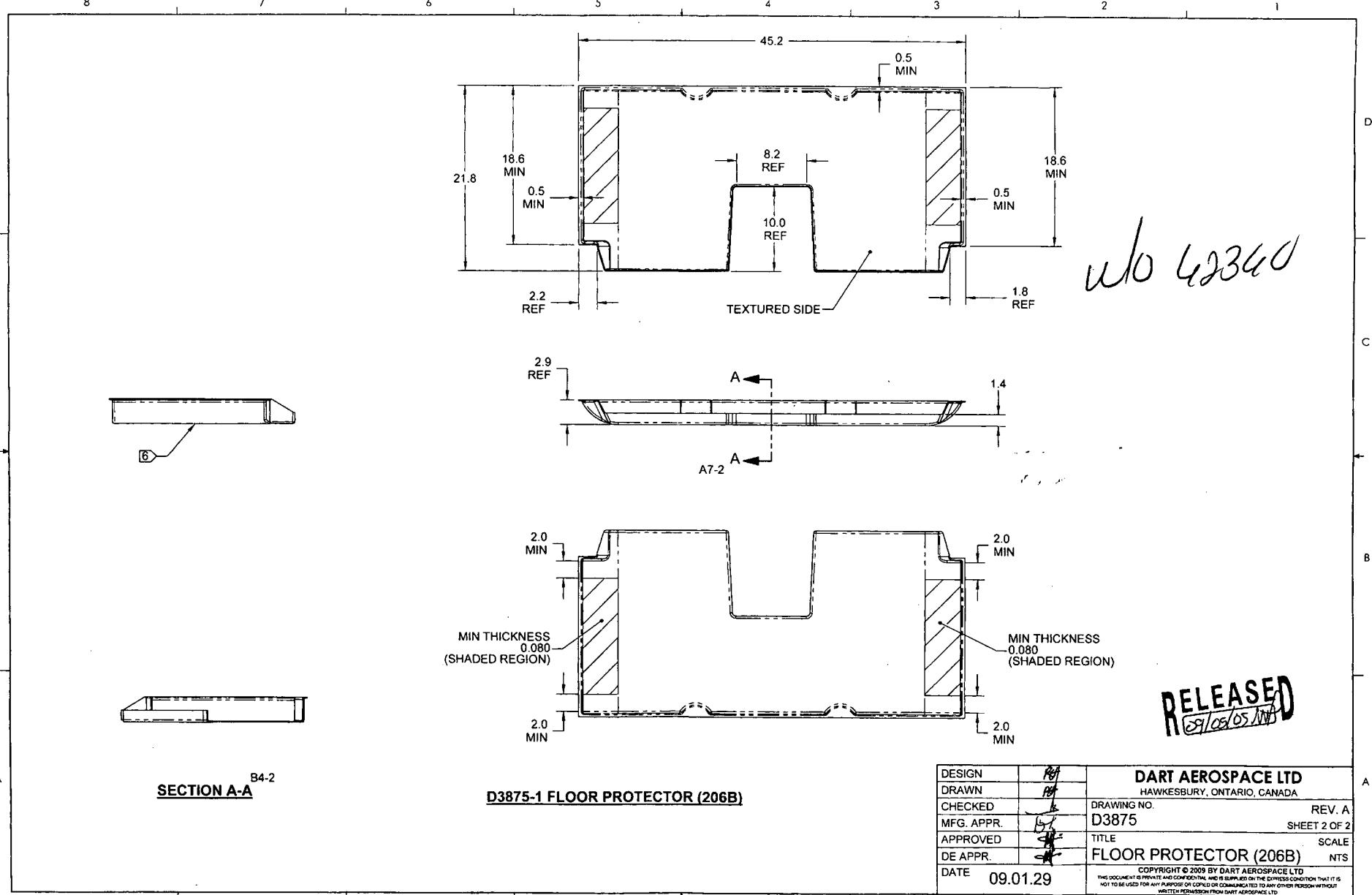
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